



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5304-1

Job Sheet 180347



Part No: D5304-1

Job Qty: 40 ea

Part Name: Crossbolt Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No:

Due Date: 7/20/18

Created By: Jesse White

Type: Stock

Description:

Note: D5304 REV.A IPP REV:A NEW ISSUE 15-09-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		7/20/18	0.00	0.00	Start Up Machining-3		JSD 18/7/19
100	Hardinge	40 pcs		7/20/18	0.00	2.92	Hardinge		JSD 18/7/19
120	QC	40 pcs		7/20/18	0.00	0.00	QC8		2018 L 18/27/19
130	Outsource	40 pcs		7/20/18			MEI001-VC	12	CT 18-26-19
140	Packaging	40 pcs		7/20/18	0.00	0.00	Packaging2		JUL 30 2018
150	QC	40 pcs		7/20/18	0.00	0.00	QC6		38
160	HandFinish	40 pcs		7/20/18	0.00	0.40	HandFinish1		D.R. 18-08-19
170	QC	40 pcs		7/20/18	0.00	0.00	QC7-5		BE
190	Packaging	40 pcs		7/20/18	0.00	0.00	Packaging3-2		JUL 30 2018
200	QC21-SA	40 Ea		7/20/18	0.00	0.00	QC21		AUG 15 2018

Part Op 100 - 1- Machine as per Folio FB

Descriptions: 130 - 1--Issue P/O to Metcore ; P/O 040546 HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061-T6 MATERIAL

160 - WASH SPACER AS PER QSI005

190 - ***STOCK IN SKIDTUBE CELL***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.750W.125	6061-T6 Round Tube .750 X .125W	17.3200 ft (.433 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.750W.125	17	12	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S093587



Part: D5304-1

Job No: 180347

Serial No/Batch: S093587

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/30/18

Plex 7/5/18 9:47 AM dart.white.jesse

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	5.200Inches $\pm$ 0.010	5.210 5.190		
2	Crossbolt Spacer	0.750Inches + 0.008 - 0.001	0.758 0.749	Diameter	
3	Crossbolt Spacer	0.125Inches $\pm$ 0.010	0.135 0.115		

Plex 7/5/18 9:47 AM dart.white.jesse



Container No: S093587



Part: D5304-1

Job No: 180347

Serial No/Batch: S093587

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/19/18

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 6A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329291	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40546	N/A	AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

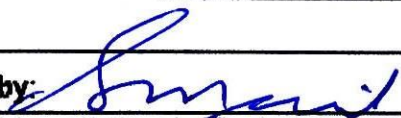
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	35 - 43 %IACS	10	40 - 41 %IACS
HARDNESS	60 HREW MIN	10	68 - 72,5 HREW
MESURE EN HR15TW = 67-69 HR15TW			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
40	5,6	D5304-1 (40) D5304-1 JOB. 180347 1 BOITE DE CARTON

30/7/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2018-07-27

APPROUVÉ

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329291	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40546	N/A	AL-6061		
SOL ANNEAL SINGLE AGING TO CONDITION T42				
SPECIFICATIONS DU PROCÉDÉ processing specifications				
EXIGENCE / requirement	SPECIFICATIONS / specified		TESTS EXÉCUTÉS / performed	
CONDUCT	35 - 43 %IACS		10 (60 kHz)	
HARDNESS	60 HREW MIN		10	
			68 - 72.5 HREW	
			MESURE EN HR15TW = 67-69 HR15TW	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
40	5.6	D5304-1 (40) D5304-1 JOB. 180347		
		1 BOITE DE CARTON		

COMMENTAIRES / comments

SOL. ANNEAL 985F, 35 MIN
AGE HARDEN AMBIANT 96 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

This document and any attached documents may contain confidential or proprietary information and may be subject to export control laws and regulations. If you are not the intended recipient, you are notified that any dissemination, copying of this e-mail and any attachments thereto or use of their contents by any means whatsoever is strictly prohibited. Unauthorized export or re-export is prohibited.

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329291	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

APPROUVÉ par / Approved by:

Isabel Otero

Isabel Otero
QA Technician



DATE: 2018-07-30



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040546

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO040546
PO Date: 7/19/18
Due Date: 7/27/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180347	D5304-1	Crossbolt Spacer 1--Issue P/O to Metcore ; P/O HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061-T6 MATERIAL	Firmed	-	7/27/18	40 pcs	0 pcs	40 pcs	\$16.675/pcs	\$667.00
Line Item Note *** BIG RUSH *** Need part back ASAP											
2	179150	646.3013	Blade ISSUE P/O: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As Per Dwg 646.3000 PART ARE MADE FROM AISI A2 TOOL STEEL	Firmed	-	7/27/18	20 pcs	0 pcs	20 pcs	\$15.625/pcs	\$312.50
Grand Total:											\$979.50

Order Notes

CT

Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/24/18 11:12 AM dart.tsimiklis.chrisoula

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL	EXPÉDITEUR	BON D'EXPÉDITION
Order	Shipper ID	Shipper
329291	1	129906

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT	BON DE LIVRAISON DU CLIENT	TYPE DE MATÉRIEL	DATE DE LA COMMANDE	TRANSPORTEUR
Customer PO	Customer Shipper No.	Material Type	Order Date	Carrier
40546		AL-6061	2018/7/20	FED

QUANTITÉ	No. PIÈCE	NOM DE LA PIÈCE	DESCRIPTION DE LA PIÈCE	POIDS
Quantity	Part No.	Part Name	Part Description	Weight

40 D5304-1
(40) D5304-1
JOB. 180347

5,6

1 BOITE DE CARTON

DAS
38
9-89

TYPE DE CONTENEUR	# DE CONTENEURS	COMMENTAIRES CONTENEUR
Container Type	# Of Containers	Container Comments
BOITE DE CARTON	1	

CERTIFICAT

EMPAQUETAGE Packing

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 40
POIDS EXPÉDIÉ / Weight Shipped : 5,60
QUANTITÉ RESTANTE / Quantity Remaining : 0
POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped:	40
POIDS EXPÉDIÉ / Weight Shipped :	5,60

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2018/07/27